

Work Order ID 58153

Monday, April 26, 2010 2:14:32 PM



Page 1

Item ID: D4021-7

Revision ID:

Item Name: Hoop

Start Date: 4/26/2010 Start Qty: 12.00

Required Date: 4/30/2010 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: MF

Date: 10-4-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4021

B

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg D4021

Prog Rev: 3

Dwg Rev: 3

Deburr as required

0.00

B10-4-28

(13)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B10-4-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Tooling:

Date:

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QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

S 10/04/09

(4/3)



QC

Quality Control

Memo

130

0.00



Small Fab

Small Fab

Memo

1- make radius as per dwg
2- deburr

0.00

S 10/05/05 (13x)

140

QC5- Inspect part completeness to step on W/O

0.00

S 10/15/05

(4/3)



QC

Quality Control

Memo

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Setup Start



Stop



Cust Item ID:

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Approvals: Process Plan:

QC:

Date:

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location:

0.00



Packaging

Basket cell

Memo

0.00

Packaging

10/05/05 *13K*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/06 *C2 10/5/14*

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Picklist Print

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Page 1

Work Order ID: 58153

Parent Item: D4021-7

Parent Item Name: Hoop

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB
DD 10.04.20 verified by:EC

Start Date: 4/26/2010

Required Date: 4/30/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Replacement Mfg/
M304B0.625X3.000 Purchased



304 BAR .625 X 3.00

Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
No			100	f	15.9000	5.2623	5.8		



1810-4-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT53

15.9

112320

13.1

112442

2.8

112320

13

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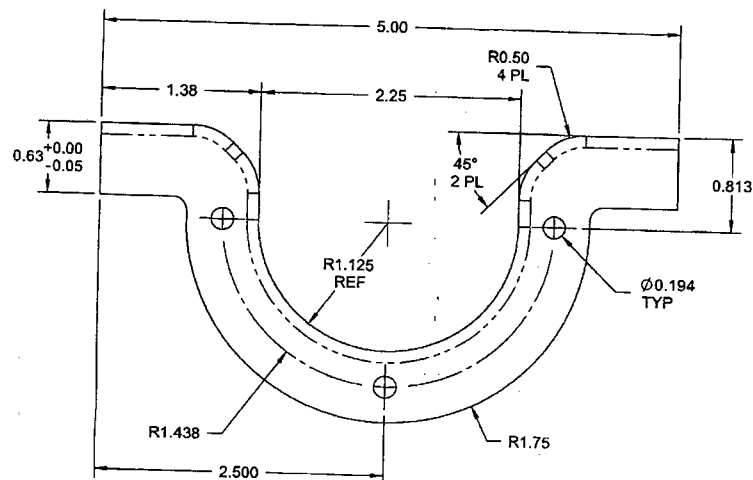
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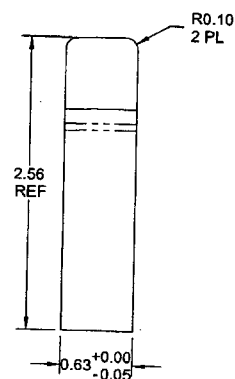
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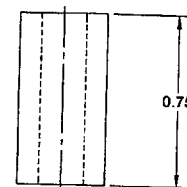
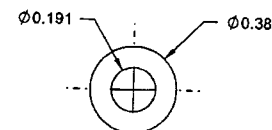
NOTE: Date & initial all entries



D4021-7 HOOP



D4021-9 BUSHING



NOTES:

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-04-14
MR

#58153

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